

Work Order ID 131894

Tuesday, April 21, 2015 2:08:59 PM

Page 1

Item ID: D3407-5

Accept

M17 4*

Revision ID:

Item Name: Ring

Start Date: 4/20/15

Start Qty: 10.00

10

Cust Item ID:

Required Date: 4/20/15

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: MLSDate: 1504-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3407

Rev E

100

0.01

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3407

Dwg Rev: EProg Rev: G

2-Break edges on manual lathe Dwg D3407 (175rpm)

0.12

10

Ø

Jm15-5-25

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

10

Ø

Jm15-5-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 131894

131894

Page 2

Tuesday, April 21, 2015 2:08:59 PM

Item ID: D3407-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Ring

Start Date: 4/20/15

Start Qty: 10.00

10

Cust Item ID:

Required Date: 4/20/15

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp
DAS
40
9-89

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

10

0

15/05/26

130

Identify as per dwg & Stock Location: *U/A 000*

0.00

130

Packaging

Memo

0.02

Packaging

*****STOCK IN LARGE FAB*****

10

EL 15-6-2

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ

JUN 11 2015

MLJ

JUN 11 2015

10

0

J.C.L. 15/05/23

121

Conv. Lathe

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Tuesday, April 21, 2015 2:08:59 PM

Page 1

Work Order ID: 131894

131894

Parent Item: D3407-5

D3407-5

Parent Item Name: Ring

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 05-11-22 JLM
IPP Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD
IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M174B0.250X4.000

Purchased

No

100

f

19.2160

0.2666

~~2.806316~~

M174B0 250X4 000

(3)

Jm15-5-25

17-4 SS Bar .250 X 4.00

Location

Loc Qty

Loc Code

MAT051

19.216

m127866

11.916

m131227

7.3

131227

DQA: _____ Date: _____



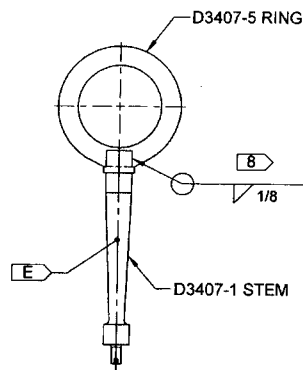
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

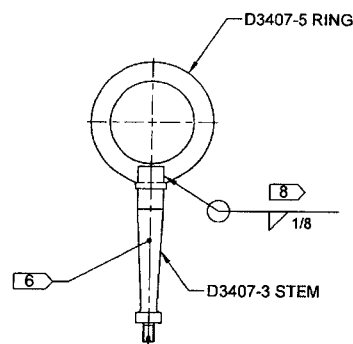
Work Order update only ☐

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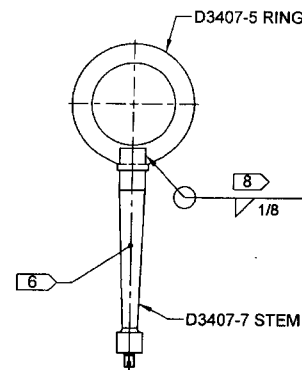
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM



D3407-041 TOW RING

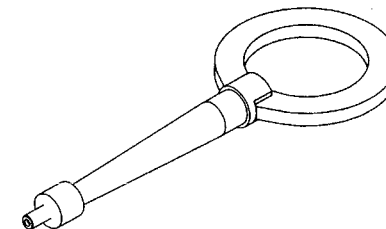


D3407-043 TOW RING



D3407-045 TOW RING

SHOP COPY
RETURN TO
FACTORY
UNCONTROLLED
SUBJECT TO
WARRANTY
NO. 131894 ML5
15-04-22

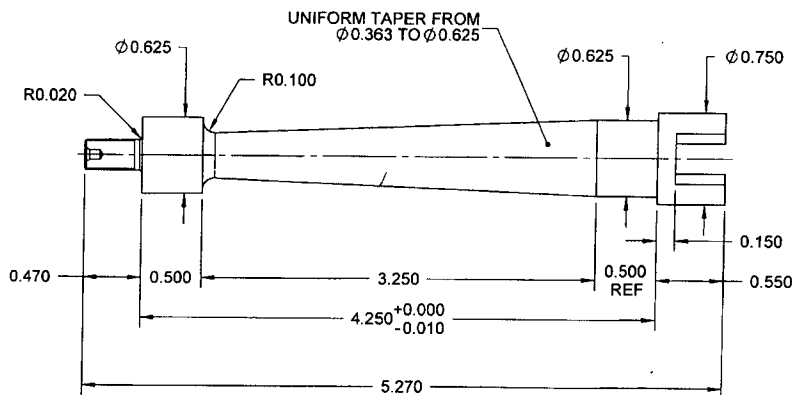
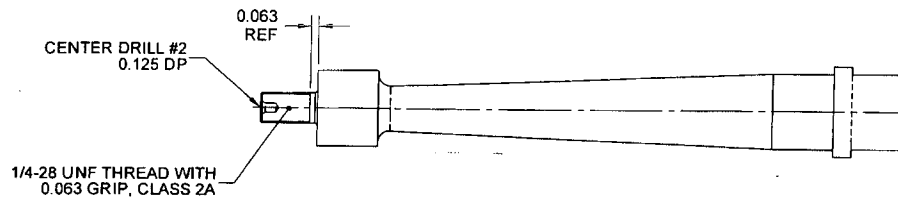


RELEASED
07-08-21

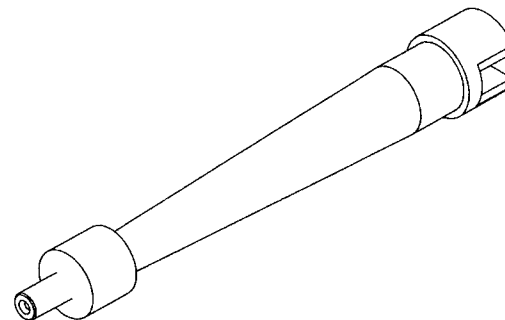
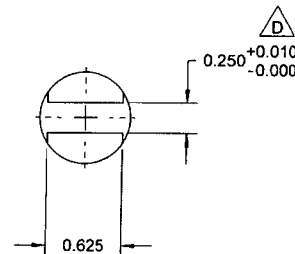
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

REV.	DESCRIPTION	BY	DATE
E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 8 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/-3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/-3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/-3 LONGER FOR FIT WWASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
DESIGN	DRAWN	CHECKED	MFG. APPR.
APPROVED	DE APPR.	DATE	08.07.23
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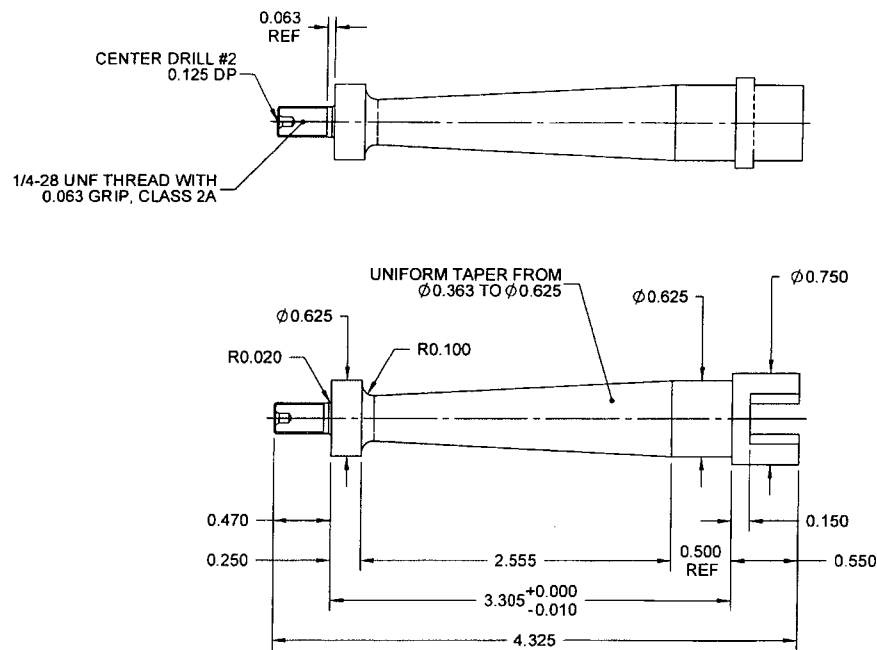
D3407-1 STEM



- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.33 lbs

RELEASED

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MFG. APPR.		D3407	SHEET 2 OF 5
APPROVED		TITLE	SCALE
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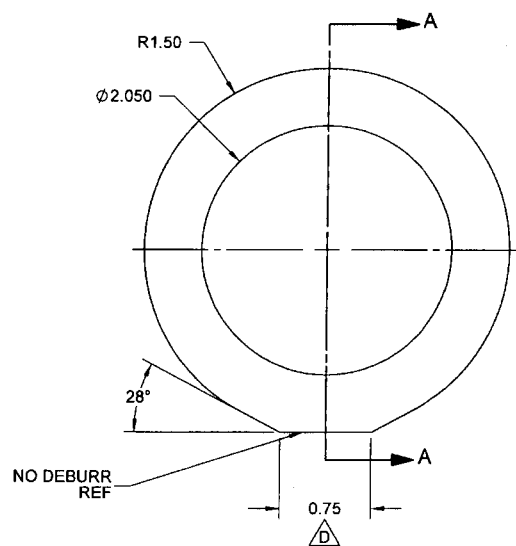
D3407-3 STEM

RELEASED

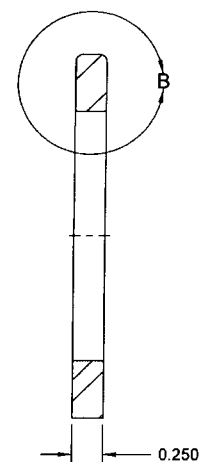
NOTES:

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.27 lbs

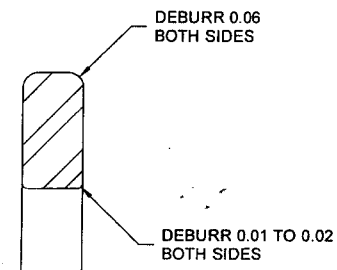
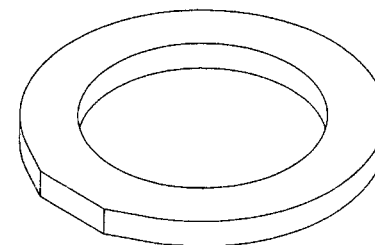
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MFG. APPR.		D3407	SHEET 3 OF 5
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D3407-5 RING



SECTION A-A



**DETAIL B
SCALE 2X**

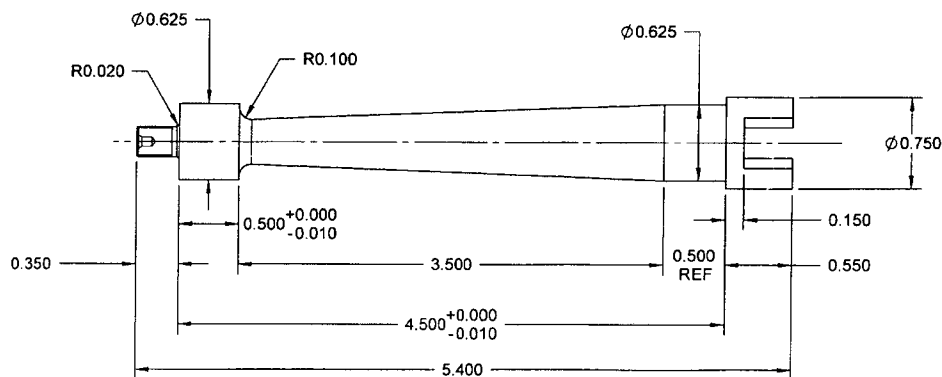
RELEASED
08-06-01/11

- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

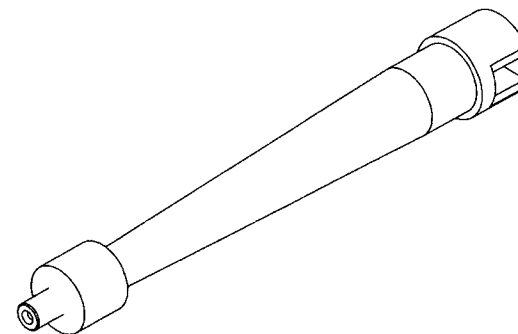
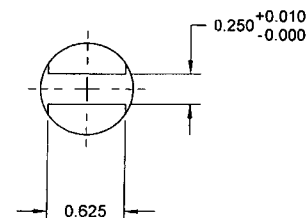
DESIGN	92	DART AEROSPACE USA, INC.	
DRAWN	1/28	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 4 OF 5
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DE APPR.		TOW RING	NTS
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0.063
REF
CENTER DRILL #2
0.125 DP

1/4-28 UNF THREAD WITH
0.063 GRIP, CLASS 2A



D3407-7 STEM



RELEASED

NOTES:

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

DESIGN	AJS	DART AEROSPACE USA, INC.	
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